

Work Order ID 81734

81734

Page 1

March-19-12 8:46:38 AM

Item ID: D4092-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Maintenance Step

Start Date: 23/03/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/03/19

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4092

B

100

Cut blanks as per folio

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

SL 12/04/12

(12)

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg and Folio FA935

Dwg Rev: B

Folio rev: AA

Deburr

12 0 12/04/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81734

81734

Page 2

March-19-12 8:46:38 AM

Item ID: D4092-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Maintenance Step

Start Date: 23/03/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

12 ϕ 12/04/03

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

B.A 12/04/04

12 ϕ

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

12X ϕ M 12/04/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81734

March-19-12 8:46:38 AM

81734

Page 3

Item ID: D4092-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Maintenance Step
 Start Date: 23/03/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 29/03/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
155	Wing Walk as per dwg QSI005 4.4 Batch	120920 0.00							
155	HandFinish	Memo 0.00				12	12	4.4	
Hand Finishing									
160	QC3- Inspect Part Finish	0.00							
160	QC	Memo 0.00							
Quality Control									
170	Identify as per dwg & Stock Location:	GA 0.00							
170	Packaging	Memo 0.00							
Packaging									

12x 0 m / 12/04/04

12/04/11 (12x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81734

March-19-12 8:46:38 AM

81734

Page 4

Item ID: D4092-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Maintenance Step

Start Date: 23/03/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/4/12
RD-04-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-19-12 8:46:42 AM

Page 1

Work Order ID: 81734

81734

Parent Item: D4092-1

D4092-1

Parent Item Name: Maintenance Step

Start Date: 23/03/2012

Required Date: 29/03/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: Ipp Rev:A New Issue 10-05-31 JLM Verified By:DD IPP
REV:B AS PER ECN 11-639 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2761-108		Manufactured	No			100	f	10.2964	2.5	31.57895			
-----------	--	--------------	----	--	--	-----	---	---------	-----	----------	--	--	--

D2761-108

Extrusion (HPK)

**

21 12/04/02

Location

Loc Qty

Loc Code

MAT007

10.29644

8323

10.29644

80206

12/04/03

31.6

~~not in computer~~

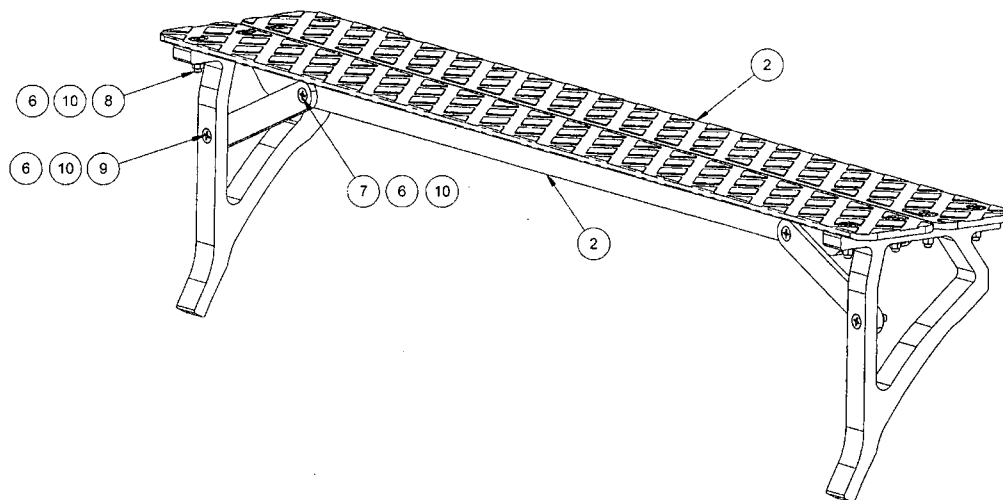
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4092-041 MAINTENANCE STEP ASSEMBLY



ITEM	QTY .041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 81734 MLCJ

12/03/19

RELEASED
R 2011-09-22

B	REDRAWN: LOWERED FOR AESTHETICS	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	MP		
MFG. APPR.	AT		
APPROVED	MP		
DE APPR.	AT		
DATE	11.07.27		

DART AEROSPACE USA, INC.

KENT, WA

DRAWING NO.

D4092

REV. B

SHEET 1 OF 6

TITLE

MAINTENANCE STEP ASS'Y

SCALE

NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

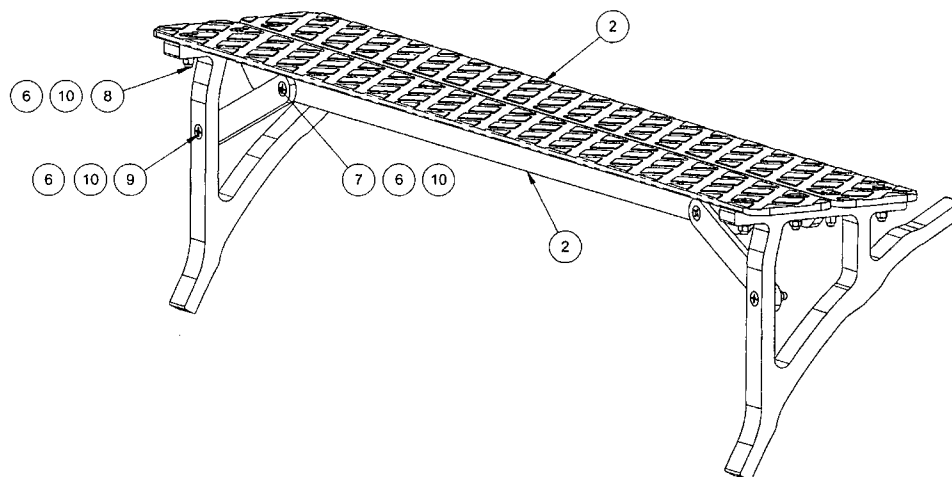
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER



D4092-042 MAINTENANCE STEP ASSEMBLY



RELEASED
2011-09-20
JW

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4092	REV. B
MFG. APPR.	<i>[Signature]</i>		SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	TITLE MAINTENANCE STEP ASS'Y	SCALE NTS
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DATE	11.07.27		

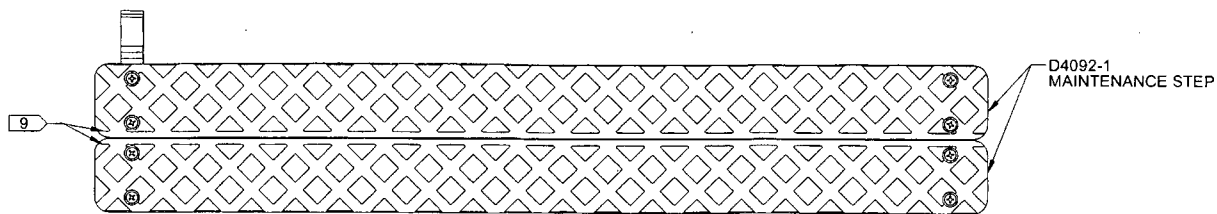
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

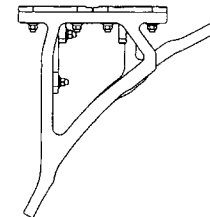
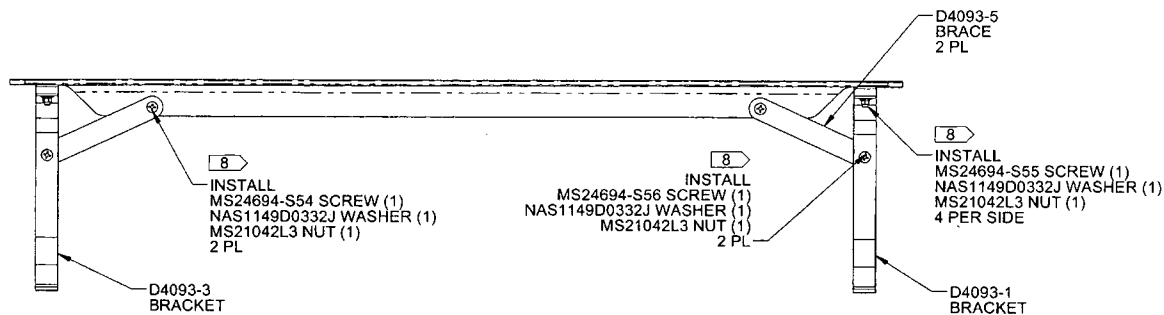
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



81734



D4092-041 MAINTENANCE STEP ASSEMBLY

RELEASED
2011-09-22

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4092	SHEET 3 OF 6
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DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

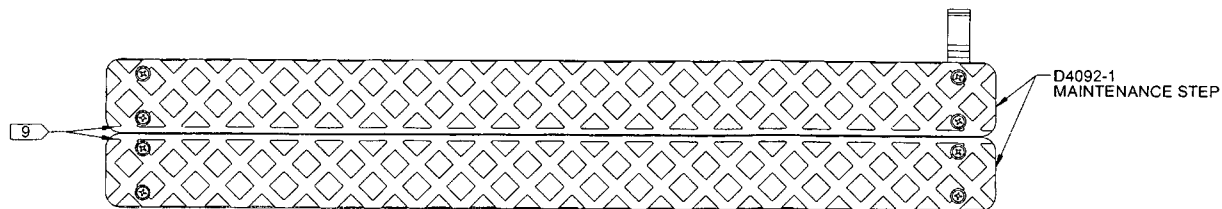
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

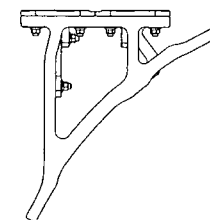
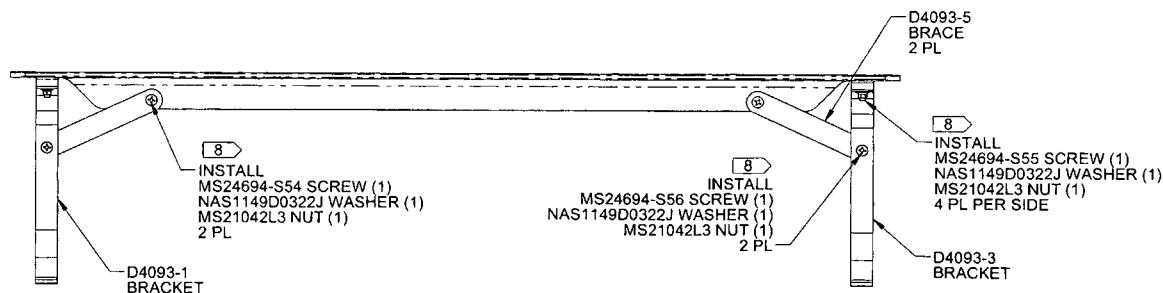
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



81734



RELEASED
2011-09-22

D4092-042 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4092	REV. B
MFG. APPR.	RF	SHEET 4 OF 6	
APPROVED	RF	TITLE MAINTENANCE STEP ASS'Y	SCALE NTS
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DATE	11.07.27		

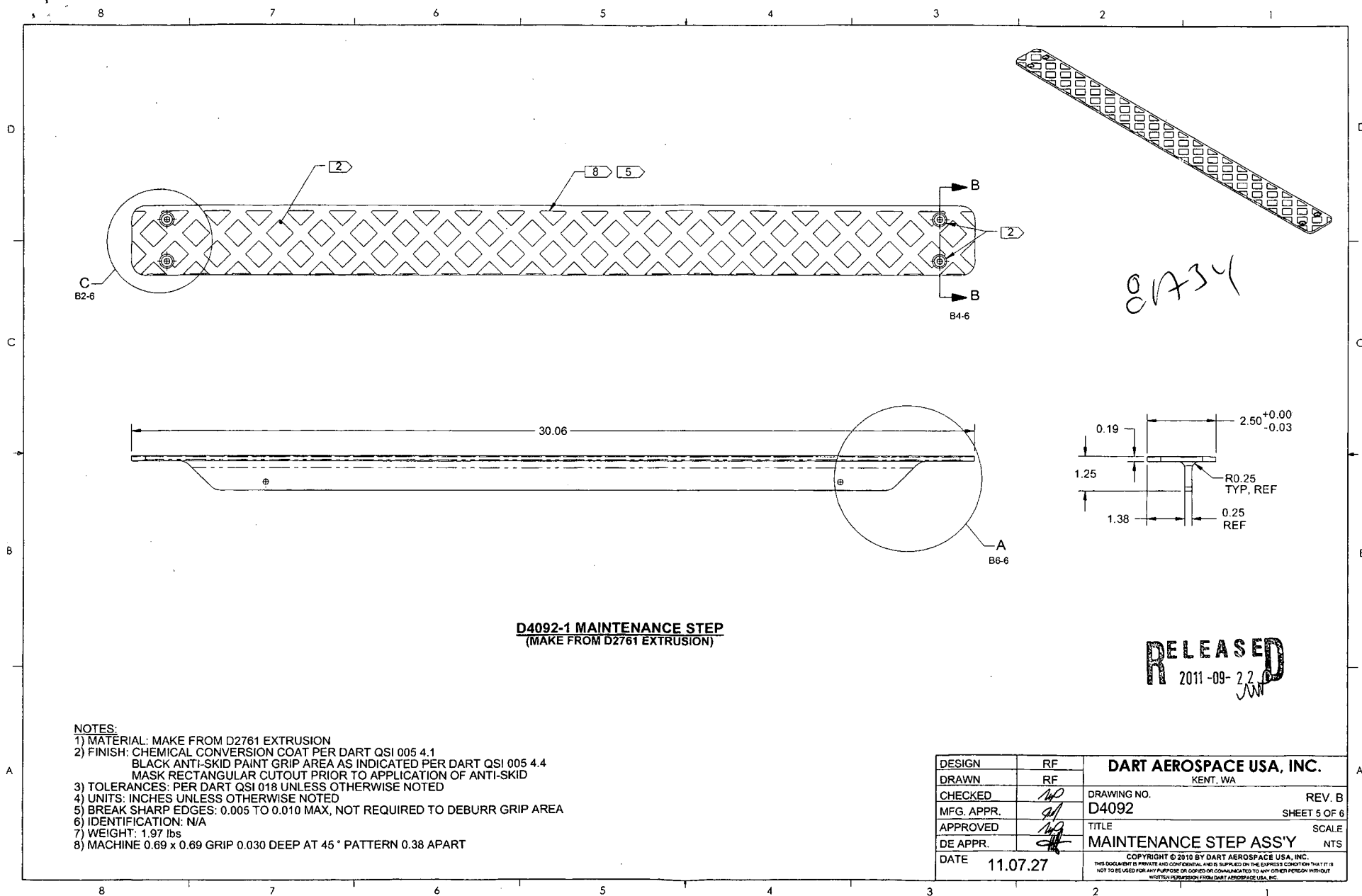
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4092-1 MAINTENANCE STEP
(MAKE FROM D2761 EXTRUSION)

RELEASED
2011-09-22
JW

NOTES:

- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4092	SHEET 5 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

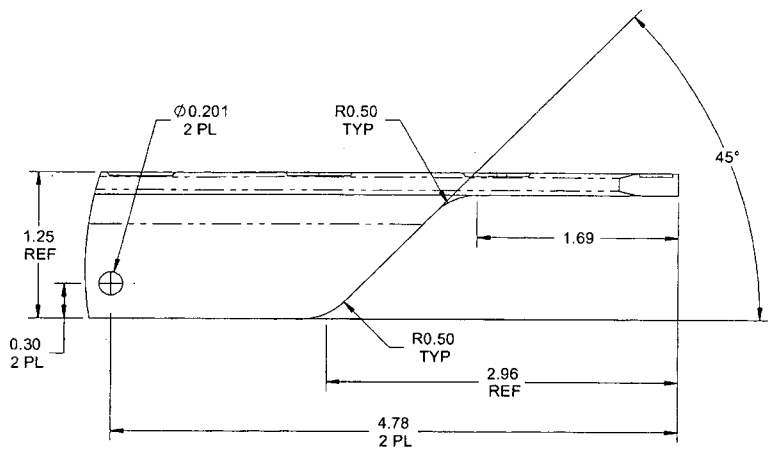
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

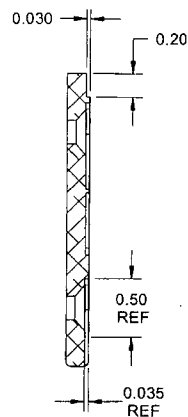
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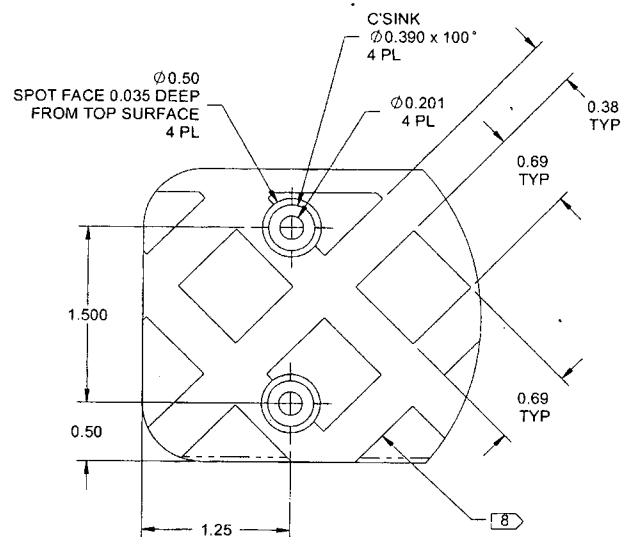
81734



DETAIL A 83-5
SCALE 3X, TYP



SECTION B-B C3-5
SCALE 3X, TYP



DETAIL C C8-5
SCALE 3X, TYP

RELEASED
2011-09-22
MMO

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4092	SHEET 6 OF 6
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MAINTENANCE STEP ASS'Y	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 81734
Description: Maintenance step		Part Number: 04092-1
Inspection Dwg: D4092 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
30.06	+/- .030	30.06	✓		SLO8	Vern Tape
2.50	+0.0/- .030	2.495	✓		SLO8	Vern
0.19	+/- .030	0.184	✓			
1.25	+/- .030	1.255	✓			
1.38	+/- .030	1.373	✓			
Ø 0.201	+ .005 / - .001	Ø 0.201	✓			
0.30	+/- .030	0.3015	✓			
R.0.50	+/- .030	R.500	✓		Rad gauge	
1.69	+/- .030	1.690	✓		SLO8	Vern
4.78	+/- .030	4.778	✓			
.030	+/- .010	.034	✓			
.20	+/- .030	.2005	✓			
.38	+/- .030	.377	✓			
.690	+/- .030	.687	✓			
Ø .201	+ .005 / - .001	Ø .201	✓			
Ø .390 X 100°	+/- .010	Ø .386 X 100°	✓			
Ø .50 X 100°	+/- .030	Ø .501	✓			
.035	+/- .010	.034	✓			
1.500	+/- .010	1.500	✓			
0.50	+/- .030	.502	✓			
1.25	+/- .030	1.251	✓			

Measured by: <i>SJ</i>	Audited by: <i>B.A</i>	Preliminary Approval:
Date: 12/04/03	Date: 12/04/04	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15